

Date: Tuesday, 7/10/2007 1:05:43 PM
 User: Kim Johnston

Process Sheet

Customer	: CU-DAR001 Dart Helicopters Services	Drawing Name	: LABEL PLATE
Job Number	: 33449		
Estimate Number	: 10599		
P.O. Number	: <i>N/A</i>	Part Number	: D2506
This Issue	: 7/10/2007 S.O. No. : <i>N/A</i>	Drawing Number	: D2506 REV E
Prsht Rev.	: NC	Project Number	: N/A
First Issue	: <i>N/A</i> Type : SMALL /MED FAB	Drawing Revision	: E
Previous Run	: 31786	Material	: <i>N/A</i>
Written By	: <i>[Signature]</i>	Due Date	: 7/17/2007 Qty: 25 Um: Each
Checked & Approved By	: <i>[Signature]</i>		
Comment	: Est. B 01.06.08 Now laser cut EC est C 06.12.13 ecn 822 ec		

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M304S20GA 304/316 .040 Sheet



Comment: Qty.: 1.2810 sf(s)/Unit Total : 32.0250 sf(s)

304/316 .040 Sheet

Batch: *M105130**SAD 07/07/28*

2.0 WATER JET FLOW WATER JET



Comment: FLOW WATER JET

1-Cut as per Dwg D

Dwg Rev: *E*Prog Rev: *E*

2-Deburr if necessary

*SAD 07/07/30 25 SAD 07/07/28**(25)*

3.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

*SAD 07/07/28**(25)*

4.0 QC8 SECOND CHECK



Comment: SECOND CHECK

*Er 07/07/31 25**(25)*

5.0 SMALL FAB 1 SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

1-Deburr if necessary.

SAD 07/07/28 25

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: R Date: 07/08/21
 QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Date: Tuesday, 7/10/2007 1:05:43 PM
User: Kim Johnston

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: LABEL PLATE

Job Number: 33449

Part Number: D2506

Job Number:



Seq. #:

Machine Or Operation:

Description :

6.0

BRAKE NC

NC BRAKE



Comment: NC BRAKE

1-Form as per dwg D2506

SIB 07/08/16

(25)

7.0

QC5

INSPECT WORK TO CURRENT STEP



coankr

Comment: INSPECT WORK TO CURRENT STEP

Sr 07/08/16 (25)

8.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location

2/215

7/8/20

(25X) 50

9.0

QC21

FINAL INSPECTION/W/O RELEASE



(50)

Comment: FINAL INSPECTION/W/O RELEASE

Sr 07/08/21

Job Completion



U 07-08-21

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART AEROSPACE LTD		Work Order:	33449
Description: Label Plate		Part Number:	D2506
Inspection Dwg: D2506 Rev: E		Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article ☐ Prototype

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
32.63	+/-0.030	32.62	✓		Vern/NT	
39.00	+/-0.030	39.00	✓		Vern	
4.50	+/-0.030	4.50	✓		Vern	
1.31	+/-0.030	1.30	✓		Vern	
1.88	+/-0.030	1.88	✓		Vern	
0.040	+/-0.010	0.040	✓		Vern	

Measured by:	SAD	Audited by:	in	Prototype Approval:	N/A
Date:	07/07/28	Date:	07/07/31	Date:	N/A

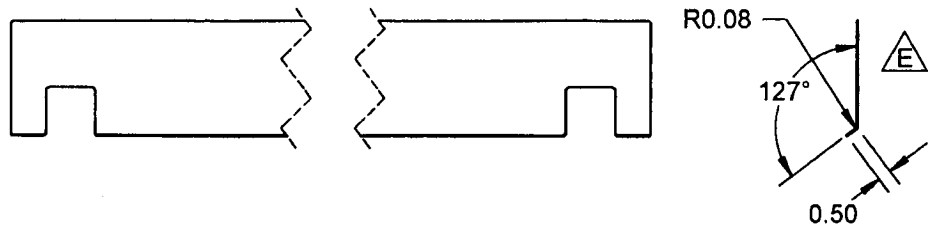
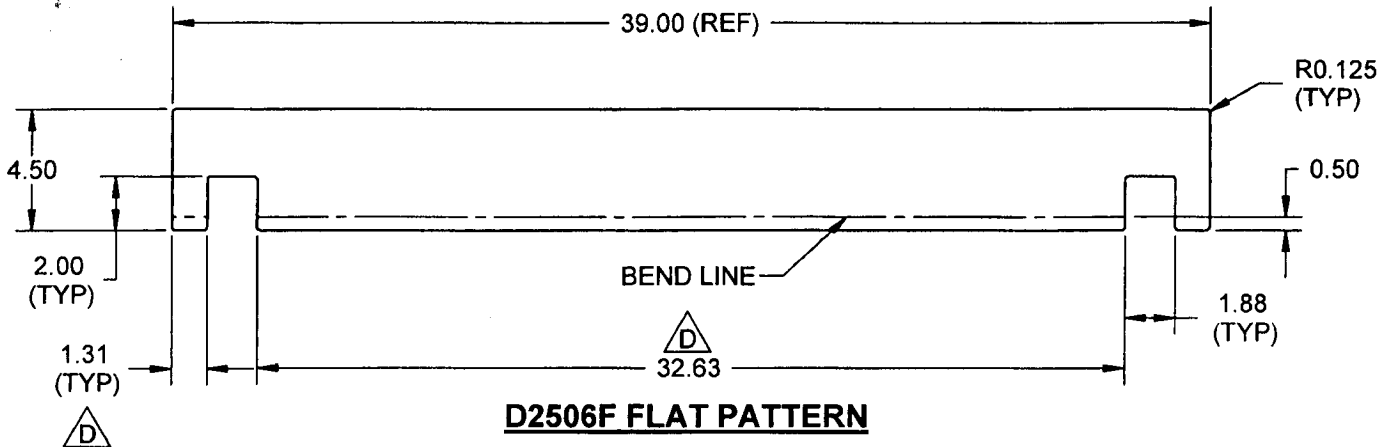
Rev	Date	Change	Revised by	Approved
A	06.08.29	New Issue	KJ/JLM	
B	06.12.20	Dwg Rev. updated	KJ/JLM	

DART

DESIGN BW	DRAWN BY CB	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED H	DRAWING NO. D2506	REV. E SHEET 1 OF 1
DATE 06.11.20	TITLE LABEL PLATE SCALE 1:7		
REV	DATE	DESCRIPTION	
A	95.11.26	NEW ISSUE	
B	96.06.18	RE-DESIGN OF LABEL PLATE	
C	96.09.04	RE-DESIGN OF LABEL PLATE	
D	99.10.04	32.63 WAS 32.25; 1.31 WAS 1.50	
E	06.11.20	REMOVE 10° BEND; ADD NOTES; 127° WAS 126°	

RELEASED

06.11.28

**NOTES:**

1) MATERIAL: STAINLESS STEEL AISI 304/316 SHEET 0.040 THICK PER MIL-S-5019 (REF DART SPEC M304S20GA)

2) FINISH: NONE

3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

4) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED

5) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX

SHOP COPY

MIL-S-5019

ENGINEERING

CONTROLLED COPY

SUBJECT TO AMENDMENT

WITHOUT NOTICE

WORK ORDER

NO. 33449

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